

Work Order ID 51390

August 20, 2009 3:37:23 PM



Page 1

Item ID:	D3512-1 GY	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	Wearplate					
Start Date:	08/24/2009	Start Qty:	12.00		Cust Item ID:	
Required Date:	08/28/2009	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan: <u>mf</u>	Date: <u>09-08-20</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3512	Rev C								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3512 <input type="checkbox"/> Dwg Rev: <u>C</u> <input type="checkbox"/> Prog Rev: <u>C</u> <input type="checkbox"/> 2- Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

B 9-9-22



B 9-9-22

> S 09/01/23



f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00							
Brake NC	Memo	0.00	SB 09/09/24			12	2		
Brake NC	Deburr if necessary <input type="checkbox"/> Form as per dwg D3512 using DT8179								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00	2) 802/02/24			(42)	1		
Quality Control									
150 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Weld hard surface using DT8874 as per Dwg D3512 & QSI 004 <input type="checkbox"/> Qty								
	Description	Batch <input type="checkbox"/> A/R	2059b	Hardcoat Rod	H 109893				
						SB 09.09.24.			

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Item ID: D3512-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Wearplate

Start Date: 08/24/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 08/28/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

⇒ 802/09/25

(42)

f

Memo

0.00

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

⇒ 802/09/25

(42)

f

Memo

0.00

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

START TIME:

1:30

FINISH TIME:

320 OF

OVEN TEMPERATURE:

2:00

M109091

M. 09/09/25

(12)

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Revision ID: C

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Required Date: 08/28/2009 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

08-05-25

200

Identify as per dwg & Stock Location: 520

0.00



Packaging

Memo

0.00

Packaging

9/9/25 120 SF

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/28 MF 09-09-26

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Picklist Print

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Work Order ID: 51390



Parent Item: D3512-1RevC



Parent Item Name: Wearplate

Start Date: 08/24/2009

Required Date: 08/28/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	206.3330	3.2968			



304/316 Sheet .063



B 9-9-22

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

206.3329737

106860

16.018

111924

33.0549737

112290

157.26

112442

112442

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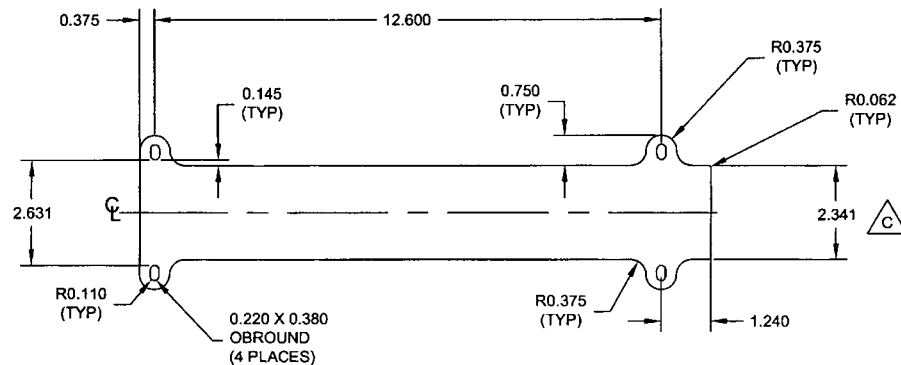
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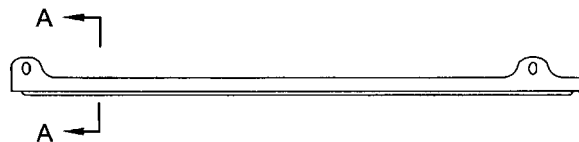
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D3512-1F FLAT PATTERN

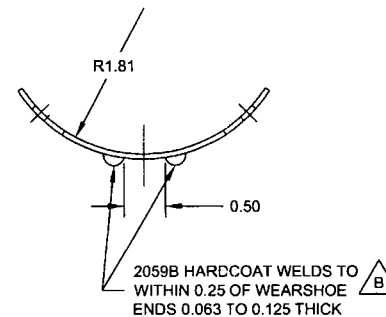


D3512-1 BENDING DETAIL



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs



SECTION A-A
SCALE 2:3

C	ENLARGE OBOURND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3512	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	1:3
DATE	07.10.05	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
07.11.16 *[Signature]*

#51390
mf
09-08-20

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mf
09-08-20

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